

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013758**Date Inspected:** 04-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Li Lin, Tu Jun
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER GRILLAGE PLATE

SMAW welding of weld joint 35A located on ESD1-TL5-2B/F.

Welder is identified as 040619. ZPMC CWI is identified as Mr. Li Lin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3213-B-U3b.

LIFT 4 STRUT PLATE

SMAW welding of weld joint 29 located on ED1-STSA4-6-139M-1.

Welders are identified as 040724. ZPMC QC is identified as Mr. Liu Dao Feng.

The welding variables recorded by QC appeared to comply with WPS-B-T-2113.

SMAW welding of weld joint 24 located on ND1-STSA4-6-131M-1.

Welder is identified as 202100. ZPMC QC is identified as Mr. Liu Dao Feng.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SMAW welding of weld joint 47A located on WD1-STSA4-5-127M-1.

Welders are identified as 040614. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

SMAW welding of weld joint 6B located on ED1-STSA4-6-131M-1.

Welder is identified as 044541. ZPMC QC is identified as Mr. Xu Jin Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

TOWER SKIRT CONNECTION BEAM (T-WR3219)

During random in process verification this QA inspector observed ZPMC personnel performing buttering of about 18mm on the edge of Tower Skirt Connection Beam. Welder is identified as 042218. ZPMC QC is identified as Mr. Shao Hui Long. The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G(1F)-REPAIR. Attached photograph provides additional details.

BAY 10

FACADE PLATE

FCAW welding of weld joint 39 located on ND1-SFSA4-90-6.

Welder is identified as 057180. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

TOWER SKIRT PLATE

FCAW welding of weld joint 1 located on WD1-A501D/E.

Welder is identified as 040533. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

SMAW welding of weld joint 38 located on WD1-A501D/E.

Welders are identified as 500373 & 040268. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
